

Work Order ID 86061

June-20-12 12:51:31 PM

86061

Page 1

Item ID: D4125-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: End

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4125

C

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1-Cut Blank at 6.500"

B.A 12/06/27

4

0

105

0.00

105

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machined as per folio FB079

Rev: AA

Dwg: C

Deburr

B.A 12/06/27

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4125-3

Revision ID:

Item Name: End

Start Date: 20/06/2012 Start Qty: 4.00

Required Date: 04/07/2012 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Sequence ID/
Work Center IDOperation
Description

110

QC2- Inspect parts off machine FAI/FAIB

110

QC

Quality Control

Memo

120

QC8- Inspect parts - second check

120

QC

Quality Control

Memo

130

Chemical Conversion Coat per QSI005 4.1

130

HandFinish

Hand Finishing

Memo

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Tooling:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

12/06/28

12/6/28

4

4

4 12-7-3

W/O:		WORK ORDER CHANGES					
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Page 3

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Item ID: D4125-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: End

Start Date: 20/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

140 QC3- Inspect Part Finish

0.00

140

QC

Quality Control

QC7

Memo

0.00

Pro

150

Identify as per dwg & Stock Location: *WMA*

0.00

150

Packaging

Memo

0.00

Packaging

4

0

12-07-05

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

OK 12/7/6.

MF 12-07-05

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Picklist Print

June-20-12 12:51:34 PM

Page 1

Work Order ID: 86061

86061

Parent Item: D4125-3

D4125-3

Parent Item Name: End

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.07.21 new issue DD verf:EC
11/12/05 as per rev.B JFS verf:DD

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X08.00 0		Purchased	No			100	f	16.8544	0.542	2.282105			

M6061T6B2 000X08 000

6061-T6 BAR 2.00' X 8.00"

**

Location

MAT005

→ 119805

→ 121626

Loc Qty

16.8544

4.8544

12

Loc Code

0.5416^{ft}

~~0.5416~~
1.665^{ft}

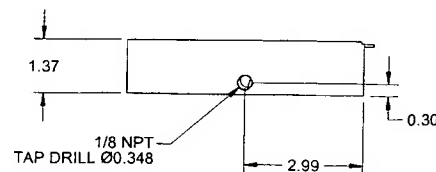
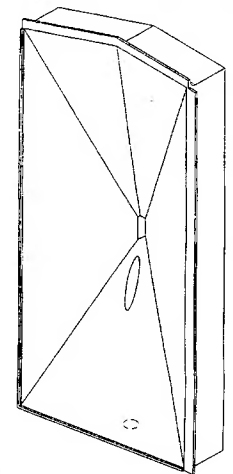
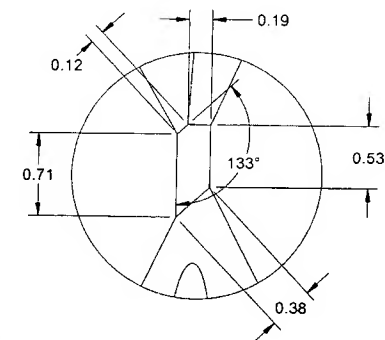
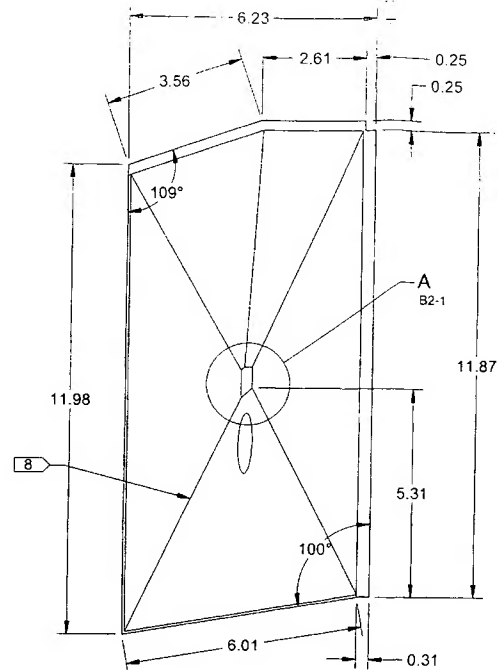
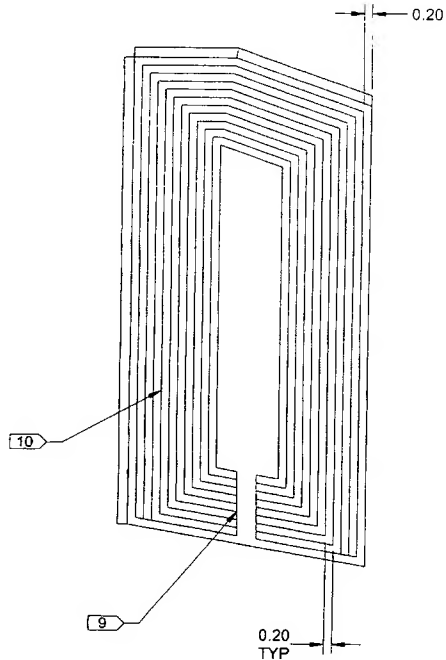
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86061 MLJ
12/06/20

DETAIL A
SCALE 3X
C5-1

RELEASED
2012-03-02
WJP

- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B1.750X6.250
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 3.26 lbs
 - 8) MAXIMUM INSIDE RADIUS = 0.250
 - 9) MINIMUM RADIUS = 0.187
 - 10) MINIMUM RADIUS = 0.015

△ D4125-1 FWD SEDIMENT BOWL

C	MODIFY DESIGN OF -1/-3: ADD PERIMETER WALL, CREATE EQUAL STEPS.	DC	11.11.29
B	MODIFY DESIGN OF -1/-3, REMOVED -041	DC	11.09.29
A	NEW ISSUE	HS	10.07.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	<u>BC</u>		
CHECKED	<u>BC</u>		
MFG. APPR.	<u>BC</u>		
APPROVED	<u>BC</u>		
DE APPR.	<u>BC</u>		
DATE	11.11.29		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4125** REV. C
SHEET 1 OF 2
TITLE **SEDIMENT BOWLS** SCALE NTS

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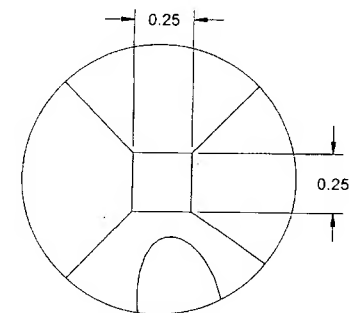
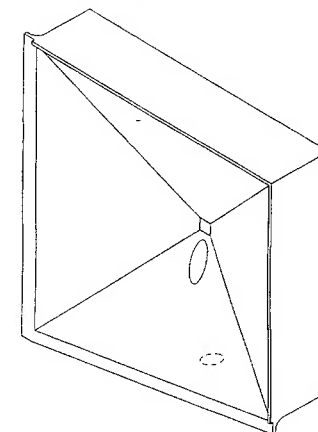
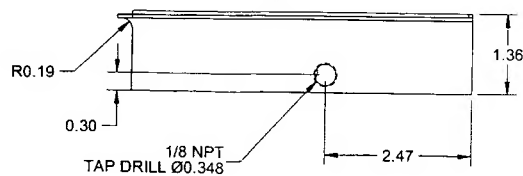
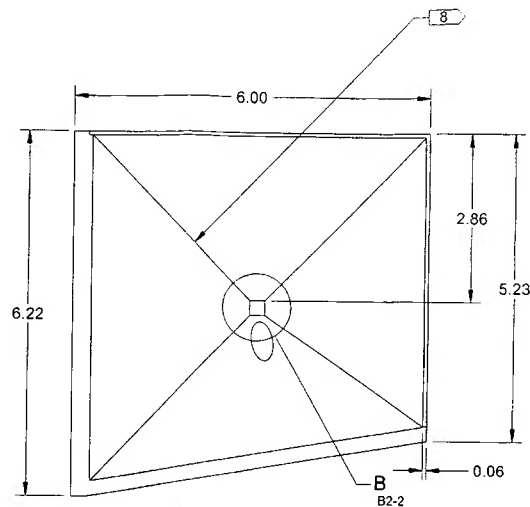
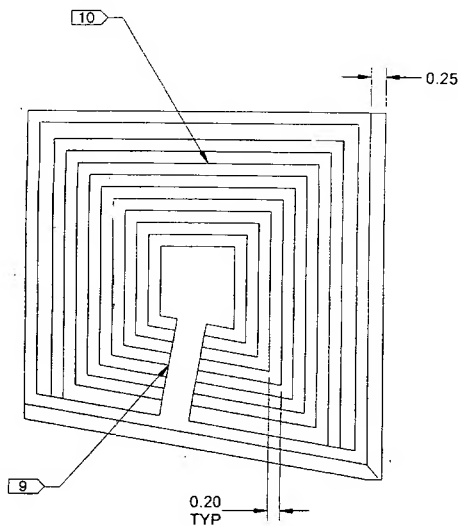
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DETAIL B
SCALE 4X
C4-2

RELEASED
2012-03-02

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
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- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs
- 8) MAXIMUM INSIDE RADIUS = 0.250
- 9) MINIMUM RADIUS = 0.187
- 10) MINIMUM RADIUS = 0.015

D4125-3 AFT SEDIMENT BOWL

DESIGN		DART AEROSPACE LTD	
DRAWN	BC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D4125	REV. C
MFG. APPR.	BC		SHEET 2 OF 2
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SEDIMENT BOWLS	NTS
DATE	11.11.29	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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